



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G00332-3G-5
Job Sheet 184950



1886
Nov. 16

Part No: RBW6405G00332-3G-5

Job Qty: 8 ea

Part Name: Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G00332-3G Rev. 5 IPP Rev. A 18.09.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Machining-3		h
110	Bandsaw	8 pcs	11/16/18	11/16/18	0.00	0.40	Bandsaw1		h
120	CNC Lathe	8 pcs	11/16/18	11/16/18	0.00	1.00	MORI SL-154		h
130	QC	8 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-4		h
140	QC	8 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-4		h
170	Outsource	8 pcs	11/16/18	11/16/18			GRO002-VC	10	h
180	Packaging	8 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2		h
190	QC	8 pcs	11/16/18	11/16/18	0.00	0.00	QC6		h
200	Packaging	8 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-1		h
210	QC21-SA	8 Ea	11/16/18	11/16/18	0.00	0.00	QC21		h

Part Op 120 - 1-Machine as per DWG. FC386 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 170 - -Issue P/O to GROUPE ALTECH: P/O 41872 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material
type; 4140 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R0.500	4140 Quenched &Tempered Steel Round Bar 0.500"	1.6800 ft (.21 ea)	90-Start up	
	Dia.	1.89	Operation	5070044=2.0

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R0.500	2	15	0

Part Specifications

could not be found.

Plex 10/19/18 8:48 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S132065



Part: RBW6405G00332-3G-5

Job No: 184950

Serial No/Batch: S132065

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 11/27/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

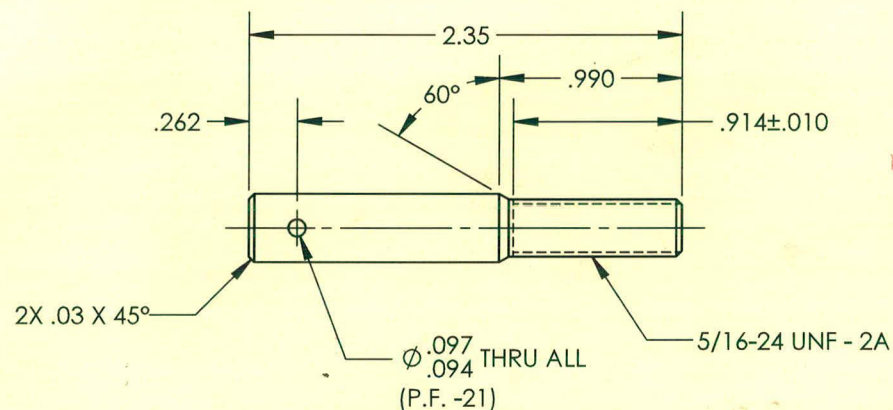
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 CH'D FINISH SPEC, ADDED MISSING HOLE DIM.	5/4/2011	RJC	
3		-5 CH'D DIM WAS Ø.372 BASIC IS Ø.374 AND LIMITS.	2/5/2013	BIM	GE
4	15-0298	-5 CH'D DIM WAS Ø.094 IS Ø.097 - .094, CH'D MATERIAL CALLOUT WAS 4140 G&P IS 4140 G&P / 4142 G&P.	9/14/2015	RJC	JAG
5	16-0233	-5 CH'D DIMS WAS Ø.374-.0012-.0019 IS Ø.3721-.3728 (S.F. -3 & -7), WAS Ø.094-.097 THRU IS Ø.094-.097 THRU ALL (P.F. -21), WAS .914 IS .914±.010, CH'D MAT'L WAS 4140 G&P / 4142 G&P IS 4140/4142. ADDED HEAT TREAT RC 28-34. CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416, TYPE II, CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2.	11/28/2016	DPD	SM

Ø.3728
Ø.3721
(S.F. -3 & -7)



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WORK ORDER
NO. 184900 WJ

187019

(5)
STUD

DART AEROSPACE	
TITLE T/R PITCH CONTROL LINK ADJUSTING TOOL	
DWG NO. RBW6405G00332-3G-5	REV 5
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 28-34	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	AGUSTA
SCALE 1:1	DATE 1/13/2008
SHEET 4 OF 7	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041872**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041872
PO Date: 11/28/18
Due Date: 12/5/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184950	RBW6405G00332-3G-5	Stud -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	12/5/18	9 pcs	0 pcs	9 pcs	\$10.00/pcs	\$90.00

9x

NOV 30 2018

Grand Total: \$90.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/28/18 3:10 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014856-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014856 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
30-Nov-2018		Aman		041872				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6405G00332-3G-5 Rev.	RBW6405G00332-3G-5 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	9	9	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

